

Ship July 15

# Work Order ID 60167

June 28, 2010 11:52:15 AM



Page 1

Item ID: D4135-1

Accept



Setup

Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 6/29/10

Start Qty: 12.00



Required Date: 7/15/10

Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Run

Start



Approvals:

Process Plan:

*[Signature]*

Date: 10/6/29

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4135

A

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

304 .063

1-Cut as per Dwg D4135

Dwg Rev: *[Signature]*

Prog Rev: *[Signature]*

2-Deburr if necessary

SB 10/06/30

(14)

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

10-6-29

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

S 10/06/30

(14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 60167

June 28, 2010 11:52:15 AM

Page 2

Item ID: D4135-1

Revision ID:

Item Name: Wearpad

Start Date: 6/29/10

Start Qty: 12.00

Required Date: 7/15/10

Req'd Qty: 12.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Setup Start

Stop

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Brake NC

Brake NC

Form as per dwg  
NC BRAKE

0.00

0.00

Memo

1- Form using DT \_\_\_\_\_ Die as per Dwg D4135

POSITIVE RECALL

EFFECTIVE 10.06.29 AUTH LP

RELEASED LP DATE 10.09.16

★ CHECK  
FIT OF (1) BENT  
PART. SEE CP

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

150

Large Fab

Large Fab

Weld per dwg A/R Hardcoat S.S. Batch: 114705

0.00

Large Fab

0.00

Memo

Weld hard surface using DT \_\_\_\_\_ as per QSI 004 and Dwg D4135

CP 10.07.14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 60167

June 28, 2010 11:52:16 AM

Page 3

Item ID: D4135-1

Revision ID:

Item Name: Wearpad

Start Date: 6/29/10 Start Qty: 12.00

Required Date: 7/15/10 Req'd Qty: 12.00

Reference:

Approvals: Process Plan: Date: Tooling: Date: SPC (Y/N):

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00 0.00				(N/A)			
170 QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							
180 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 M112588 Memo START TIME: 1:00pm OVEN TEMPERATURE: 320°F FINISH TIME: 1:30pm	0.00 0.00							

Diagnosis

10-07-14

10/07/15 14 d

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 60167**

June 28, 2010 11:52:16 AM

Page 4

Item ID: D4135-1

Accept

Setup Start

Stop

Revision ID:

Item Name: Wearpad

Start Date: 6/29/10 Start Qty: 12.00

Required Date: 7/15/10 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Run Start

Stop

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: \_\_\_\_\_  
Packaging

0.00

Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10-07-15

10/7/16 19

10-07-16

MP  
10-7-16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June 28, 2010 11:52:12 AM

Page 1

Work Order ID: 60167

Parent Item: D4135-1

Parent Item Name: Wearpad



Start Date: 6/29/10

Start Qty: 12.00

Required Date: 7/15/10

Required Qty: 12.00

Comments: IPP Rev:A 10.06.25 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty
M304S16GA		Purchased	No			100	sf	77.3439	0.01653	0.2088

M304S16GA



304/316 Sheet .063



B10-6-09

## Location

MAT

111323

114799

## Loc Qty

77.34389474

0

77.3438947

## Loc Code

114799

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

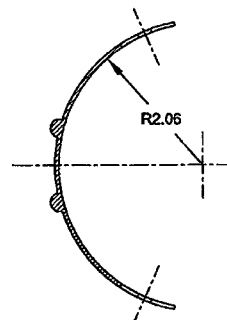
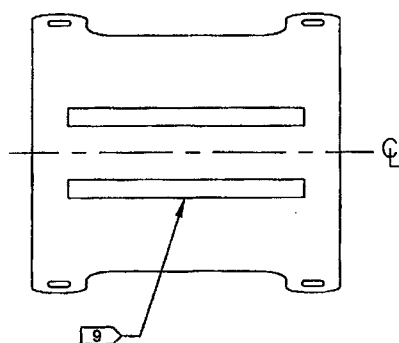
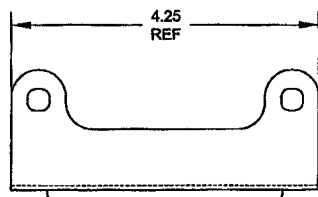
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

SHOP COPY

RETURN TO  
ENG'G DEPT  
UNCONTI... COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
W/ "ORDER"  
NO. 40167  
PS 10-6-07



**D4135-1 WEARPAD**

**NOTES:**

- 1) MATERIAL: MAKE FROM D4135-1F
- 2) FINISH: POWDER COAT "GREY SANDEK" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4135-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.33 lbs
- 8) WELD PER QSI 004
- 9) 2059B HARDCOAT WELDS, 0.063 TO 0.125 HIGH

**RELEASED**  
2010-06-23  
WP

A	NEW ISSUE		CP	10.06.15
REV.		DESCRIPTION	BY	DATE
DESIGN	92	DART AEROSPACE USA, INC		
DRAWN	92	PORT HADLOCK, WA		
CHECKED	92	DRAWING NO.	REV. A	
MFG. APPR.	92	D4135	SHEET 1 OF 2	
APPROVED	92	TITLE	SCALE	
DE APPR.	92	WEARPAD	NTS	
DATE	10.06.15	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC		
THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.				

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries

